

Date: Tuesday, 7/18/2006 3:01:31 PM  
 User: Kim Johnston

## Process Sheet

29

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 4-MAN SIDE FACING SHOULDER HARNESS KIT,4  
 Job Number : 27978 POINT /  
 Estimate Number : 12184  
 P.O. Number : N/A Part Number : D412702027  
 This Issue : 7/18/2006 S.O. No. : N/A Drawing Number : D3196 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A  
 Previous Run : N/A Material : N/A  
 Due Date : 7/21/2006 Qty: 2 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : AS 06.07.18  
 Comment : Est. A 05.09.01 New issue KJ/JLM  
 Est Rev:B 06.04.03 As per DSI9324 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Issue Travelers for:

Batch

D412-702-027 4-Man Side Facing

Shoulder Harness Kit

D3446-041 Harness Assembly

Note: D412-702-027 Kit consists of (1) D3196-3; (1) D3196-4; (4) D3446-041

Photocopy bluefile and create labels per PPP D412-702-027CHG001

See attached.

2.0

M6061T6B0750X01500

6061-T6 Bar .75" X 1.5"



Comment: Qty.: 6.1031 f(s)/Unit Total: 12.2063 f(s)

6061-T6 Bar .75" X 1.5"

Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)

(M6061T6B0.750x01.500)

Identify (1) for D3196-3

Identify (1) for D3196-4

Batch:

3.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut (2) blanks per (1) D412-702-027 Kit

Cut blanks: (0.75" x 1.50") x 34.750" long Bar

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 7/18/2006 3:01:31 PM  
User: Kim Johnston

*sup. reviewed*  
**Process Sheet**

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 4-MAN SIDE FACING SHOULDER HARNESS KIT, 4 POINT /

Job Number: 27978

Part Number: D412702027

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



**Comment:** HAAS CNC VERTICAL MACHINING #1  
Machine D3196-3 as per Folio FA339 and Dwg D3196

Identify as D3196-3

Machine D3196-4 as per Folio FA339 and Dwg D3196

Identify as D3196-4

Deburr

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK



**Comment:** SECOND CHECK

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



**Comment:** HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1  
D3196-3/-4

8.0

POWDER COATING

POWDER COATING



**Comment:** POWDER COATING  
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3  
D3196-3/-4

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

D31963

Bar



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bar  
Pick: Packing Kit  
(Note: D3196-3/-4 are on BOM as material from Steps 3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 7/18/2006 3:01:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 4-MAN SIDE FACING SHOULDER HARNESS KIT, 4 POINT /

Job Number: 27978

Part Number: D412702027

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty Part Number Description Batch

1 D3196-3

Bar

B 24130- , B 26930

11.0

D31964

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bar

Qty Part Number Description Batch

1 D3196-4

Bar

B 26889

12.0

D3446041

Harness Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Harness Assembly

Qty Part Number Description Batch

4 D3446-041

Harness Assembly

B 26777

13.0

MS24694S152

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Qty Part Number Description Batch

6 MS24694-S152

Screw

M100680

14.0

MS24694S154

SCREW



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

Batch: 100680

M.F. 06/07/19 (2)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AB 06/07/19 (2)

16.0

PACKAGING 1

PACKAGING RESOURCE #1




Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-027

AP 06/07/19 (2)  
M.F. 06/07/19 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 7/18/2006 3:01:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 4-MAN SIDE FACING SHOULDER HARNESS KIT, 4 POINT /

Job Number: 27978

Part Number: D412702027

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

106.07.20

Job Completion



11 10-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

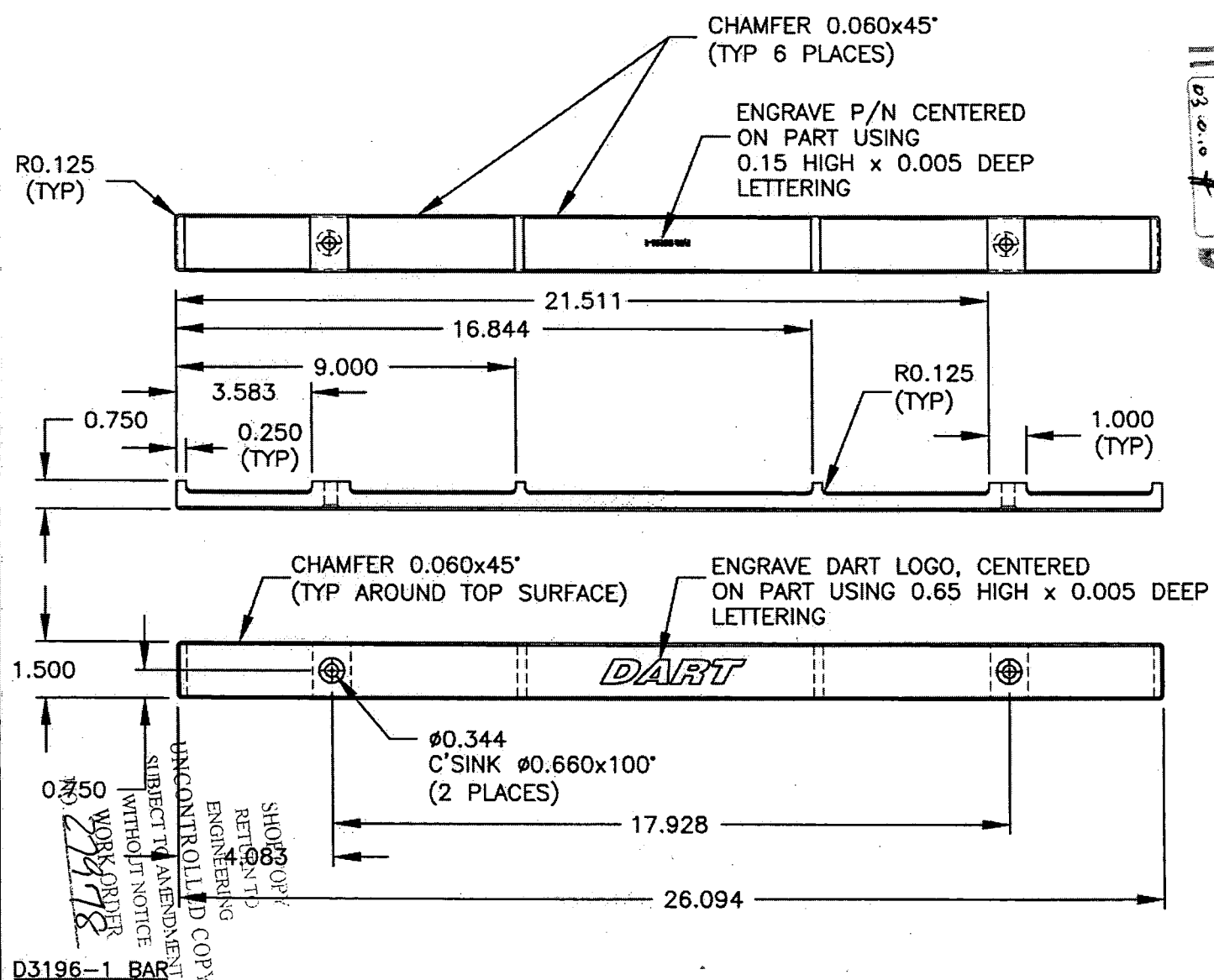
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





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03.06.25

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CHECKED	03	APPROVED	03	REV. A
DATE	03.06.25	DRAWING NO.	D3196	SHEET 1 OF 3
		TITLE	BAR	SCALE
A		NEW ISSUE		1:4



- D3196-1 BAR
- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
  - 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
  - 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES

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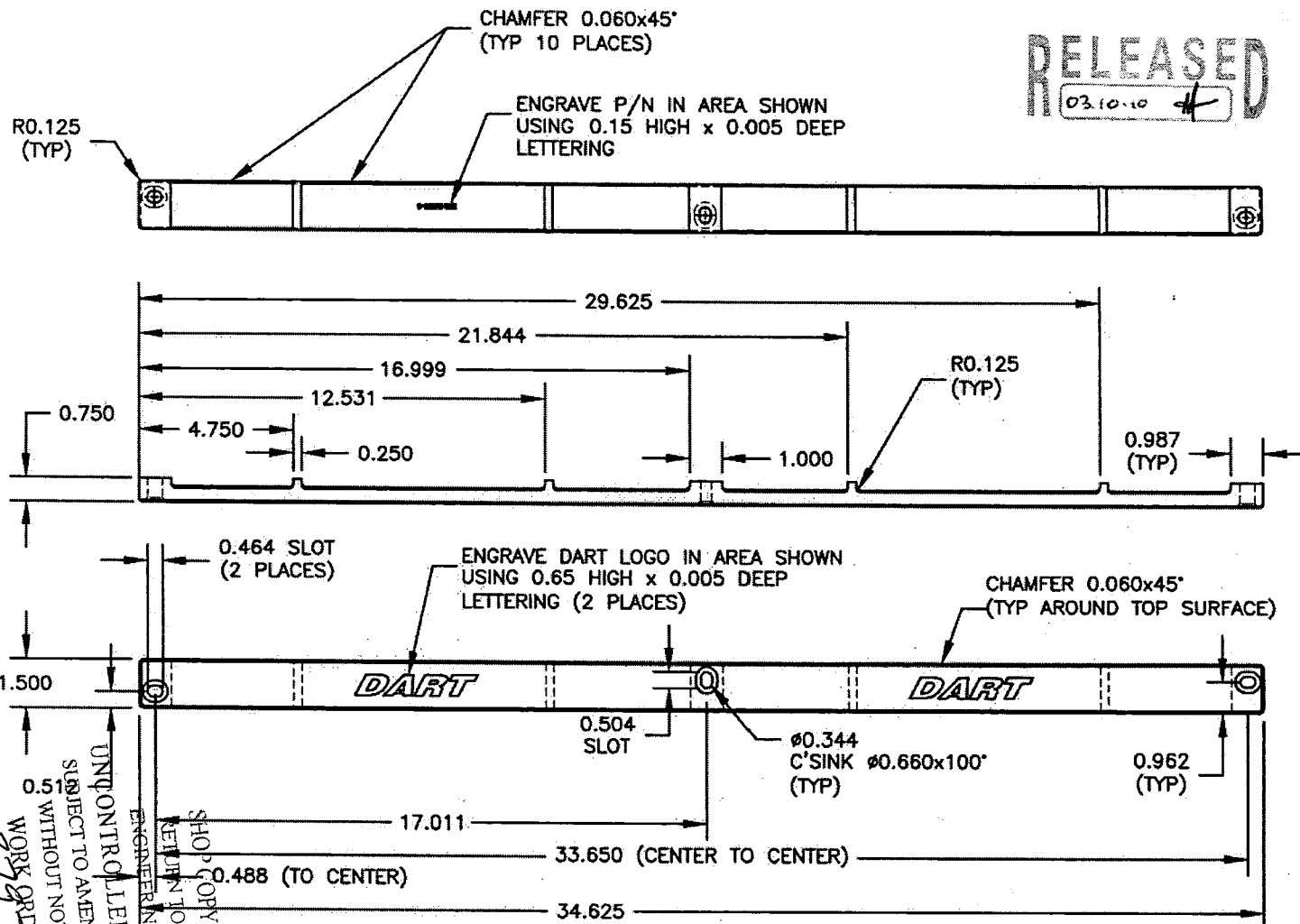
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03.10.10

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CHECKED	W	APPROVED	W	REV. A
DATE	03.06.25	DRAWING NO.	D3196	SHEET 2 OF 3
		TITLE	BAR	SCALE 1:5

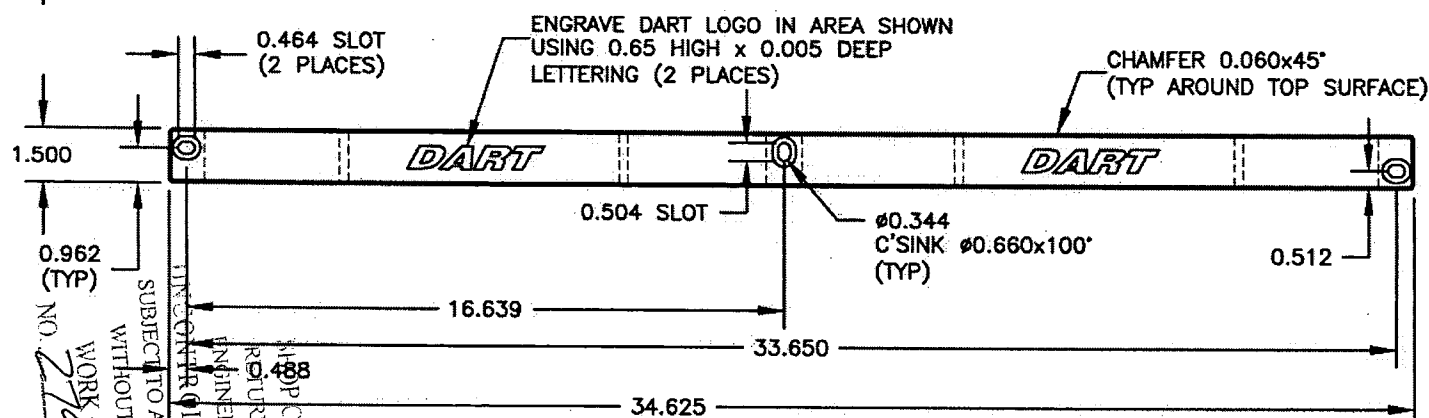
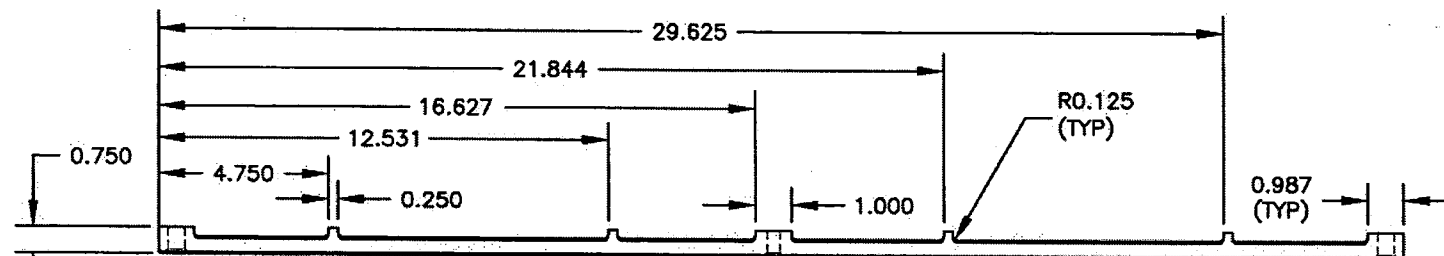
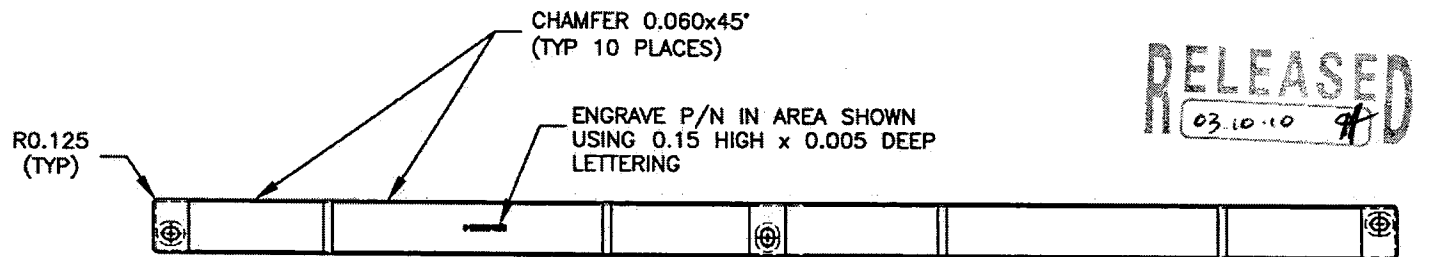


**D3196-3 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

WORK ORDER  
NO. 27978  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
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ENGINEERING  
DEPT  
COPY

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAMESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. A
DATE	DRAWING NO.	SHEET 3 OF 3
03.06.25	D3196	SCALE
	TITLE	1:5
	BAR	